

Work Order ID 69617

Thursday, May 12, 2011 3:36:07 PM



Page 1

Item ID: D3560-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 5/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/05/12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3560	Rev D	07/05/12

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut blanks 15.500" long

0.00

11/05/12

2 0

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1- Mill as per Folio FA696 Rev: A & Dwg D3560 Rev: D
 2-C'sink 0.196" hole on manual mill as per dwg D3560
 3-Deburr per dwg D3560

0.00

B.A 11/06/02

7 0

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B.A 11/06/02

7 0

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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11/06/02	160	Thickness of material is 0.485 instead of 0.500".	CP 11/06/02 PSI042	Acceptable. PER DR-D412-630-2 Appendix A, "I" values are still above previous design values	B.A 11/06/02	cmf 11/06/03	CP 11/06/02 PSI042	S 11/06/02

NOTE: Date & initial all entries

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Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC8- Inspect parts - second check

0.00

ML 11/06/03

7 0

QC

Memo

0.00

Quality Control

140



Large Fab

0.00

7 0

Large Fab

Memo

0.00

H 11/06/03

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC5- Inspect part completeness to step on W/O

0.00

8/11/08/08

0.00

C+7

2044

QC

Quality Control

160



QC9- Inspect visual per QSI004- Fusion Welds

0.00

7/8/2011/06/07

QC

Quality Control

170



Chemical Conversion Coat per QSI005 4.1

0.00

K 11.06.08

E 8

HandFinish

Hand Finishing

0.00

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC3- Inspect Part Finish

0.00

8 9 11 106108

QC

Memo

0.00

Quality Control

190



Small Fab

0.00

850/06/09 7

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

200



QC5- Inspect part completeness to step on W/O

0.00

8 106109

QC

Memo

0.00

Quality Control

67 044

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Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: WA

0.00

11-06-09

7

Ø

Packaging

Packaging

Memo

*** STOCK IN STEP CELL***

0.00

220



QC21- Final Inspection - Work Order Release

0.00

MF
11-06-09

QC

Quality Control

Memo

0.00

MF
11-06-09

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Picklist Print

Thursday, May 12, 2011 3:36:13 PM

Page 1

Work Order ID: 69617



Parent Item: D3560-044



Parent Item Name: Arm Weldment

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP Rev B ECN 987 07.10.09 EC verified by DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808 		Manufactured	No			100	Each	11.0000	1	2		
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--

Bushing

Location	Loc Qty	Loc Code
GA	11	
32896	2	
46738	9	

M6061T6B0.500X05.00 0 		Purchased	No			140	f	16.0000	1,295	2.726316		
------------------------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--

6061-T6 Bar .500 x 5.00

Location	Loc Qty	Loc Code
MAT004	16	
412154	16	

D3592-1 		Manufactured	No			190	Each	75.0000	1	2		
-------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--

Plate

Location	Loc Qty	Loc Code
WA002	75	
47015	27	
48517	48	

117788
~~117788~~ 9.065 on 11/05/31

~~117788~~ 9.065 on 11/05/31
11-06-06

7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	49617
Description: Arm	Part Number:	D3560-4
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B.A.	Audited by:	One	Prototype Approval:	N/A
Date:	11/06/02	Date:	11/06/03	Date:	N/A

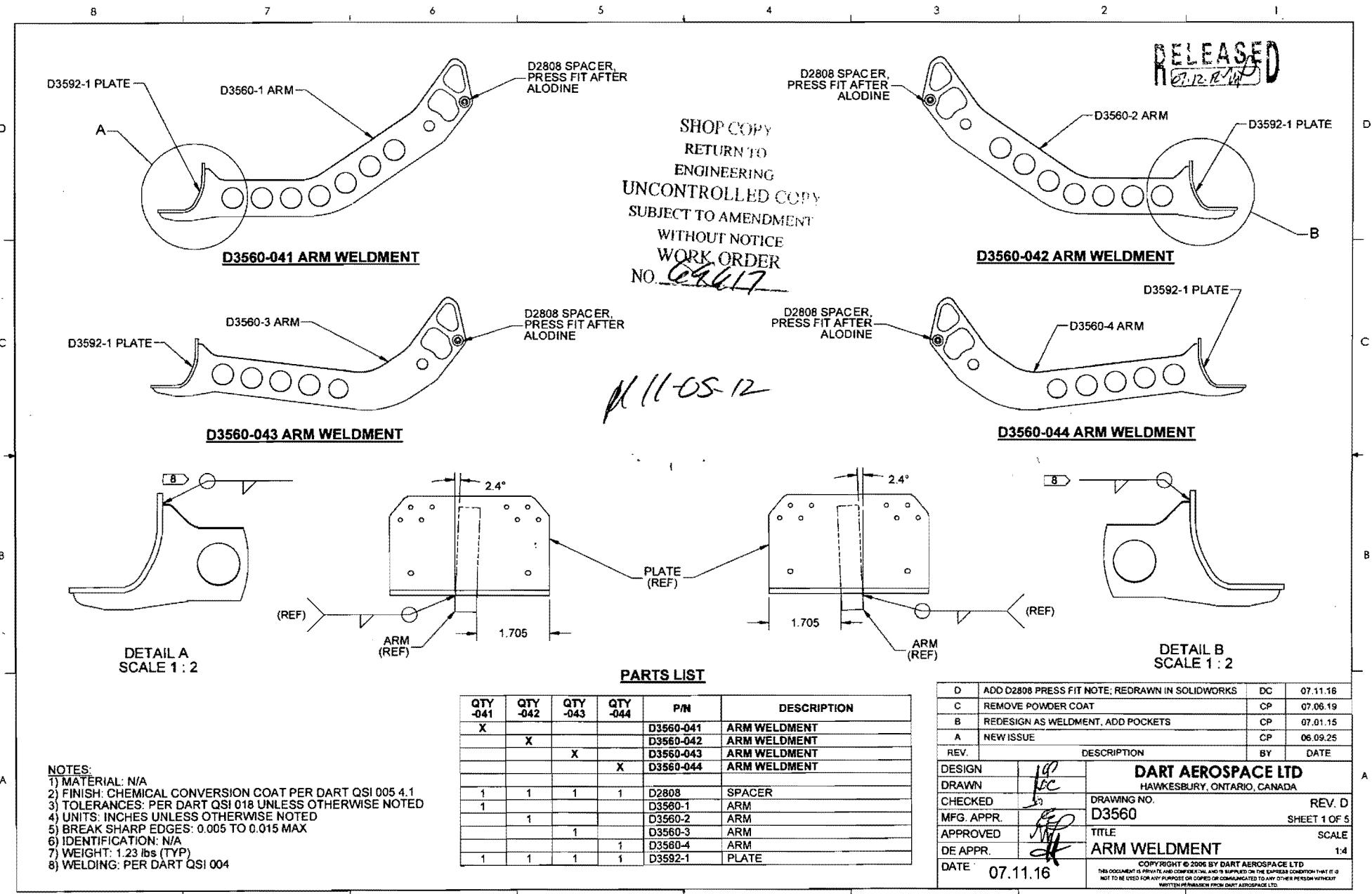
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	10.02.02	Dimensions updated per Dwg Rev C	KJ	AA

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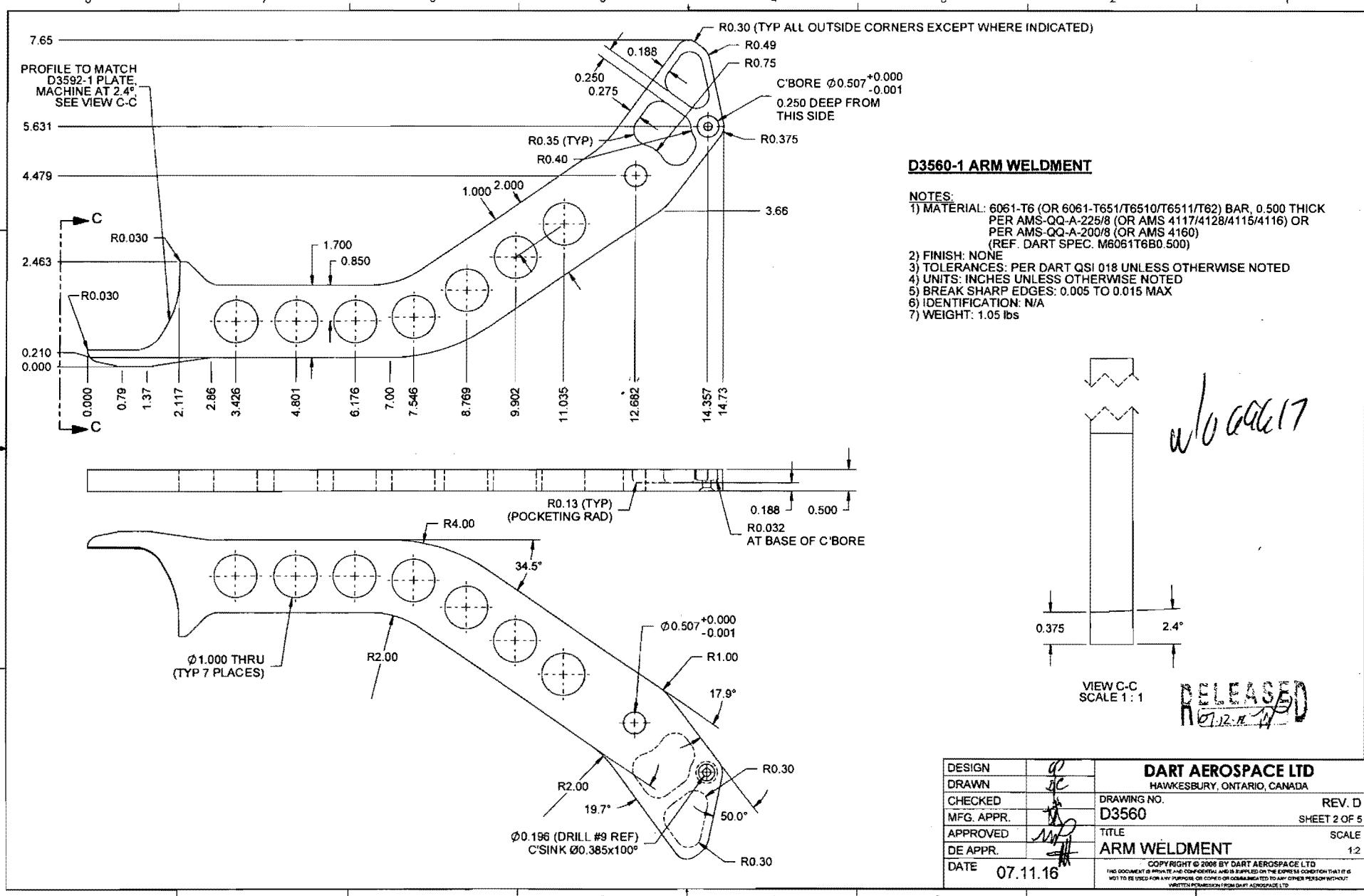
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DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED	1	
MFG. APPR.	1	DRAWING NO. D3560
APPROVED	1	REV. D SHEET 2 OF 5
DE APPR.	1	TITLE ARM WELDMENT
DATE	07.11.16	SCALE 1:2

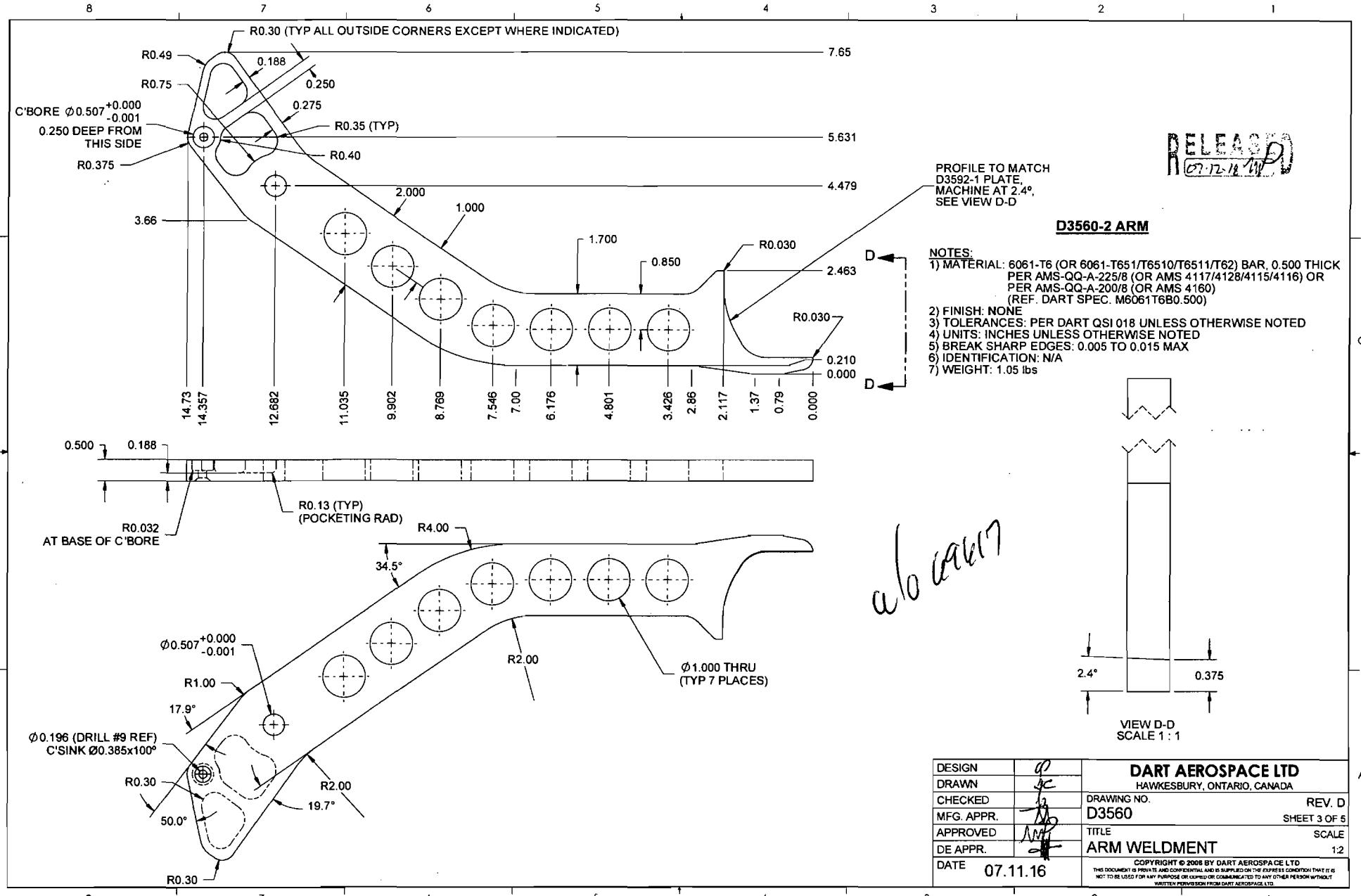
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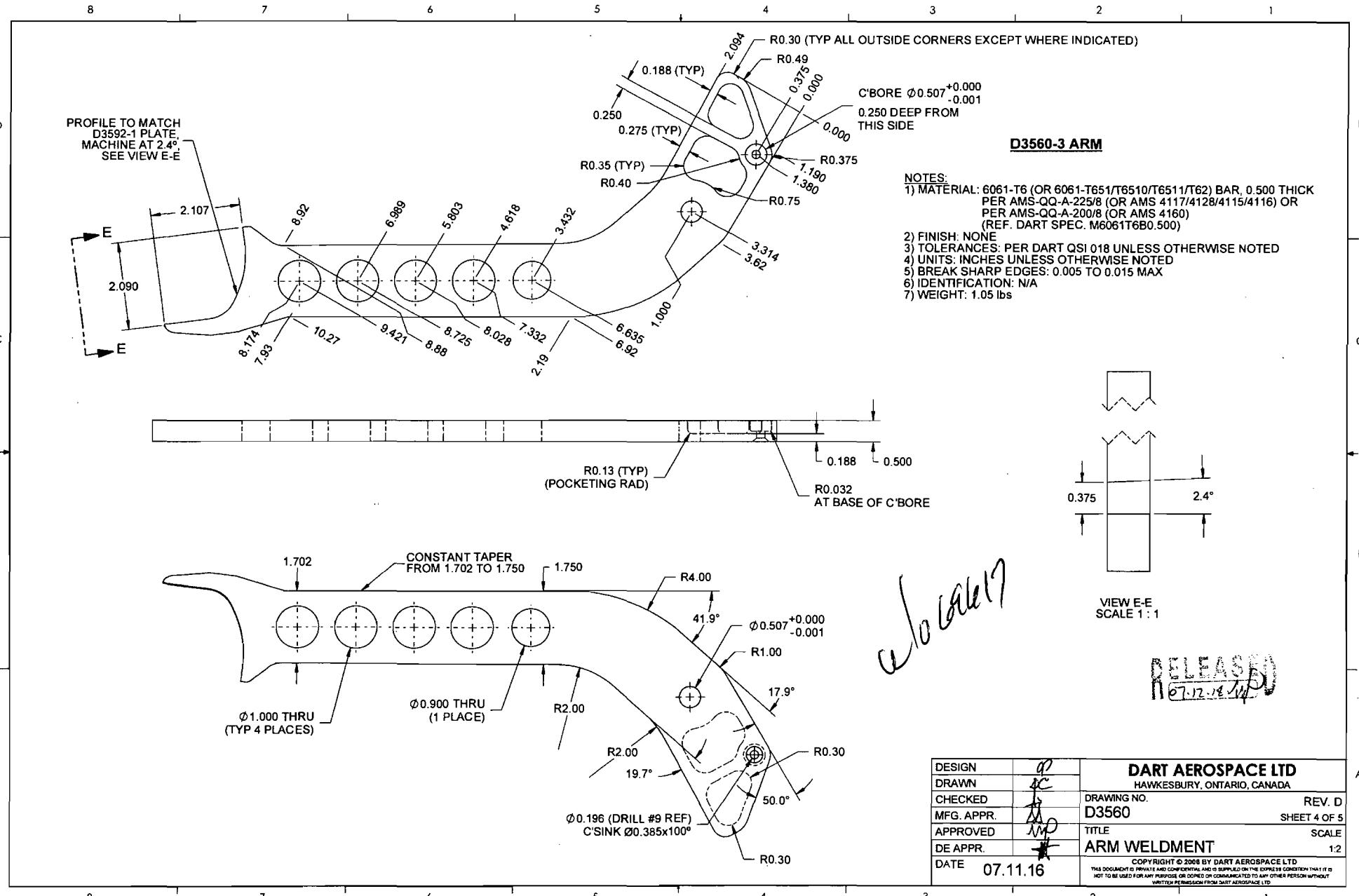
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DESIGN	<i>9</i>	DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>J</i>	DRAWING NO.	
MFG. APPR.	<i>AS</i>	REV. D	
APPROVED	<i>NP</i>	D3560	
DE APPR.	<i> </i>	SHEET 4 OF 5	
DATE	07.11.16	TITLE	
		ARM WELDMENT	
		1:2	
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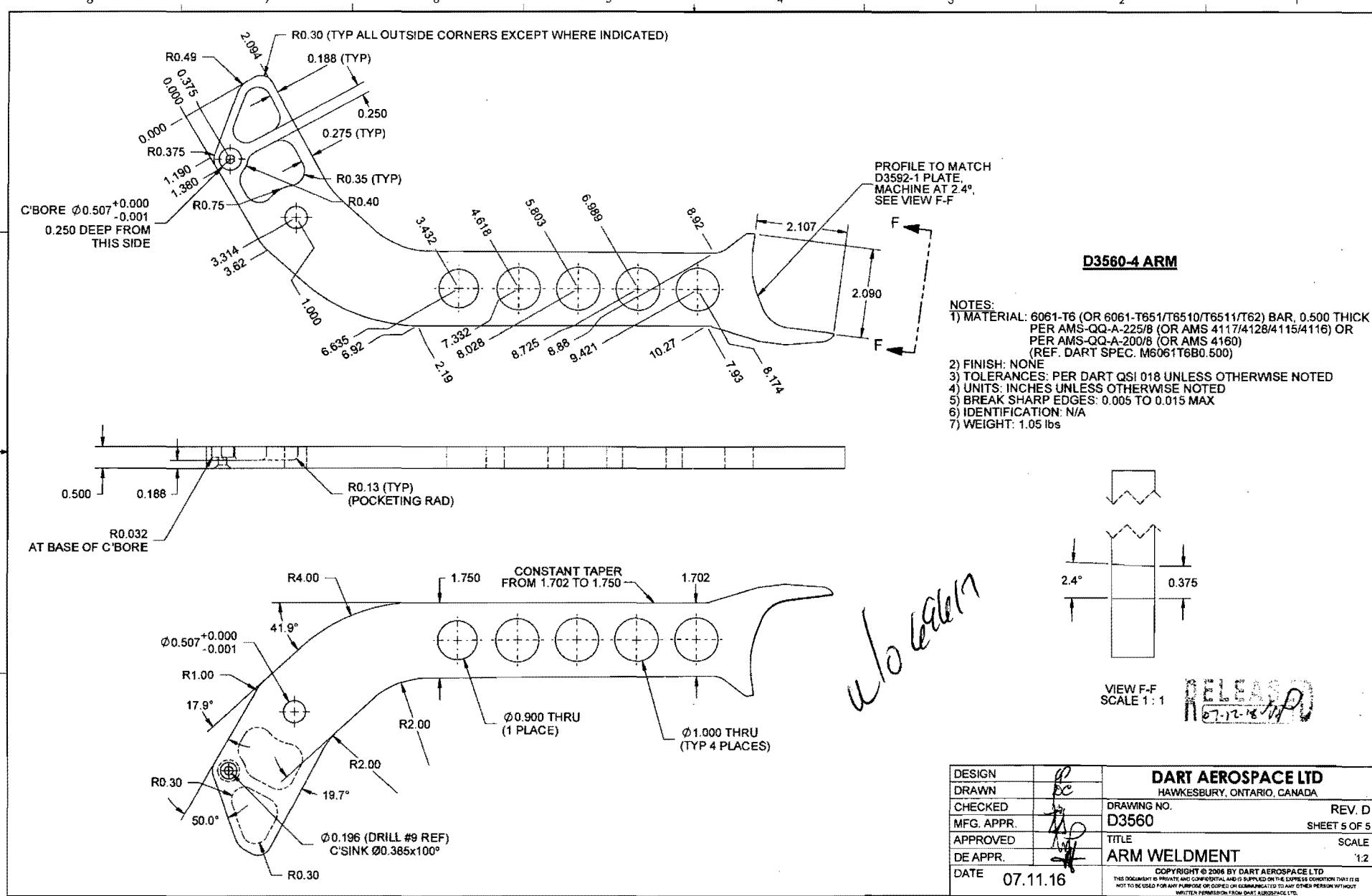
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